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D2804-042
Job Sheet 188636



Part No: D2804-042

Job Qty: 2 pcs

Part Name: RH Step Fwd Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP Rev:G As per Rev C 06-11-08 JLM IPP
REV:H 16.06.23 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	1/25/19	0.00	0.14		Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS
							Small Fab - 4		36
							Small Fab - 5		9-89
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	1/25/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		DAS
							QC 5 - 68		FEB 12 2019 68
							QC 5 - 9		9-89
							QC 5 - 50		
							QC 5 - 30		
120	Powdercoat - 1 White GI(A) -B4B	2 pcs	1/25/19	0.00	0.10		Powdercoat - 1 - B4B		let 10-2-13
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
130	QC 3	2 pcs	1/25/19	0.00	0.00		QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	DAS
					QC 3 - 36	36
					QC 3 - 38	9-89
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
150 Small Fab - 2 - B4B	2 pcs	1/25/19	0.00 0.14		QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	DAS
					Small Fab - 4 - B4B	36
					Small Fab - 5 - B4B	9-89
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
160 QC 5	2 pcs	1/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	FEB 26 2019 58
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
170 Packaging 3-1 - Stock - B4B	2 pcs	1/25/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

Entered: _____ Date: _____



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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	ST 474
				Packaging 3 - 28 - B4B	98 FEB 28 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				QC 21 - SA - 21	DAC
				QC 21 - SA - 70	21 FEB 28 2019
180 QC 21 - SA	2	1/25/19	0.00 0.00		
	pcs				

Part Op 100 - (Small Fab) Press D2805-2 and D2809 into arm as per Dwg D2804

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 8:20pm OVEN TEMPERATURE: 320°F

FINISH TIME: 9:50pm

130 - QC3- Inspect Part Finish

150 - (Small Fab) 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2804-2	Bracket	2 pcs (1 ea)	100-Small Fab - 1	F157888x1 F144642x1
D2805-2	Stop	2 pcs (1 ea)	100-Small Fab - 1	5147933
D2809	Washer	2 pcs (1 ea)	100-Small Fab - 1	5072531
AN3C16A	Bolt	4 Ea (2 ea)	150-Small Fab - 2 - B4B	505495
D3672-15	Phenolic Washer	8 pcs (4 ea)	150-Small Fab - 2 - B4B	5040894
MS21043-3	Nut	4 Ea (2 ea)	150-Small Fab - 2 - B4B	519144

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2804-2	2	4	0
	D2805-2	2	1	0
	D2809	2	27	0
150-Small Fab - 2 - B4B	AN3C16A	4	54	0
	D3672-15	8	544	0
	MS21043-3	4	880	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



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Date : _____	Sequence # _____	MRB (QSI042)																																									
Description Work Order De		Completed By																																									
 Container No: S150106  Part: D2804 - 042 Job No: 188636 Serial No/Batch: S150106 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/01/19		Lead hand / Supervisor																																									
		QC / QA Coordinator																																									
		Root Cause																																									
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